

Work Order ID 154342

Friday, December 09, 2016 7:41:02 AM

154342

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Item ID: D4271-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting Assembly Fwd Beam
 Start Date: 12/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/8/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: DEC 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	D								
100		0.00							
100									
Small Fab	Memo	0.07							
Small Fab	Assemble as per dwg D4271 REAM HOLE AS PER DWG CUT RIVET AT 1.130" C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>S1346</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS
6
9-89

①

DEC 2 2016

1X

DAS
36
9-89
17/01/20

DAS
38
9-89

JAN 2 0 2017

DAS
6
9-89

JAN 2 4 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00					21 9-89	JAN 26 2017	
130									
QC	Memo	0.02							
Quality Control									


JAN 24 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process								
Misidentified ☐	☐	Past Due								
			OTHER : ☐							

Picklist Print

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Work Order ID: 154342

154342

Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 12/6/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.20 new issue EC veriufied by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5 *D4149-5* Eyebolt Stud		Manufactured	No			100	Each	12.0000	1	1			
									**		DAS 6 9-89		DEC 27 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST086				12					
				152216				8					
				153099				4					
D4419-1 *D4419-1* Fwd Support Plate		Manufactured	No			100	Each	1.0000	2	2			
									**		DAS 6 9-89		DEC 27 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST097				1					
				151096				1					
D4281-1 *D4281-1* Spacer		Manufactured	No			100	Each	13.0000	1	1			
									**		DAS 6 9-89		DEC 27 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST090				13					
				145905				13					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	2.0000	1	1			
									**		DAS 6 9-89		DEC 27 2016
				<u>Location</u>				<u>Loc Qty</u>					
				ST090				2					
				145996				2					

DAS 36
154136 9-89 (X)
154316

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

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Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 12/6/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No

100 Each 86.0000 2 2

AN4C13A
BOLT

DAS
6
9-89

DEC 21 2016

Location	Loc Qty	Loc Code
GA	6	
m134754	6	
OVER002	50	
m136263	50	
ST344	30	
m136192	30	

~~136145~~

2

MS20427M4-20 Purchased No

100 Each 73.0000 1 1

MS20427M4-20
RIVET

DAS
36
17/01/209-89

Location	Loc Qty	Loc Code
GA	73	
118429	73	

1

10

MS20615-4M18 Purchased No

100 Each 85.0000 10 10

MS20615-4M18
Rivet

DEC 21 2016

Location	Loc Qty	Loc Code
GA	40	
m134762	40	
ST306	45	
m136182	45	

10

DAS
6
9-89

DQA: _____ Date: _____



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Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
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Parent Item: D4271-025

D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 12/6/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,180.000

2

2

MS21043-4

Nut

DAS
6
9-89

DEC 21 2016

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

over003

400

m136148

400

OVER007

600

m136192

300

m136263

300

ST302

123

m135600

123

2

NAS1149C0432R

Purchased

No

100

Each

1,775.000

4

4

NAS1149C0432R

WASHER

DEC 21 2016

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136182

1000

ST266

402

m135979

402

4

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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